



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2938-2
Job Sheet 179300



Part No: D2938-2

Job Qty: 4 ea

Part Name: Saddle RH Out, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Machining-1		VH 18/8/12
100	CNC Vertical Machining	4 pcs	6/29/18	6/29/18	0.22	4.12	HAAS1-2		
110	Mill Conv	4 pcs	6/29/18	6/29/18	0.00	0.50	Mill Conv 1		
120	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC1		
130	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC8 Machining-1		
140	HandFinish	4 pcs	6/29/18	6/29/18	0.00	0.18	HandFinish1		
150	Powdercoat	4 pcs	6/29/18	6/29/18	0.00	0.16	Powdercoat1		
160	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC3		
170	Packaging	4 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-1	ST 395 98	AUG 22 2018 9-89
180	QC21-SA	4 Ea	6/29/18	6/29/18	0.00	0.00	QC21		DAS AUG 24 2018 21 9-89

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - START TIME: 2.15 00.1.50 FINISH: 2.45.

M 38893

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	4	95	0

Part Specifications

could not be found.

Plex 6/18/18 9:29 AM Dart.lajeunesse.marie



Container No: S101273



Part: D2938-2

Job No: 179300

Serial No/Batch: S101273

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/11/18

DART AEROSPACE LTD	Work Order: 179300
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.129	0.129	0.128	0.130		
B	0.100	0.140		0.128	0.129	0.128	0.128		
C	0.100	0.140		0.125	0.125	0.123	0.123		
D	0.210	0.230		0.217	0.226	0.227	0.226		
E	1.245	1.255	✓	1.250	1.250	1.250	1.250		
F	1.245	1.255	✓	1.250	1.250	1.250	1.250		
G	2.495	2.505	✓	2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582	✓	1.577	1.577	1.577	1.577		
J	2.495	2.505	✓	2.500	2.500	2.500	2.500		
K	0.257	0.262	✓	0.257	0.257	0.257	0.257		
L	0.312	0.317	✓	0.313	0.313	0.313	0.313		
M	0.235	0.240		0.239	0.239	0.238	0.239		
N	0.100	0.140		0.118	0.120	0.119	0.119		
O	0.540	0.560		0.546	0.550	0.551	0.544		
P	0.490	0.510		0.500	0.501	0.500	0.502		
Q	3.715	3.725	✓	3.720	3.720	3.720	3.720		
R	2.720	2.760	✓	2.740	2.740	2.740	2.740		
S	0.240	0.270		0.264	0.265	0.264	0.264		
T	0.100	0.180		0.135	0.136	0.135	0.135		
U	1.625	1.635	✓	1.630	1.630	1.630	1.630		
V	1.362	1.372	✓	1.367	1.367	1.367	1.367		
W	0.316	0.321	✓	0.316	0.316	0.316	0.316		
X	1.250	1.270	✓	1.260	1.260	1.260	1.260		
Y	1.565	1.585	✓	1.575	1.575	1.575	1.575		
Z	0.178	0.198	✓	0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	
Date:	

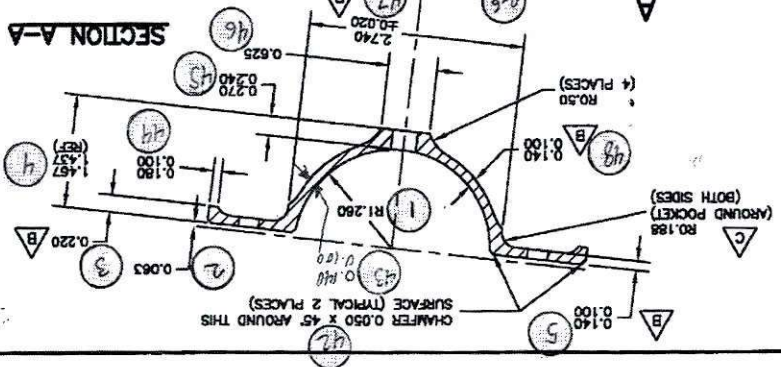
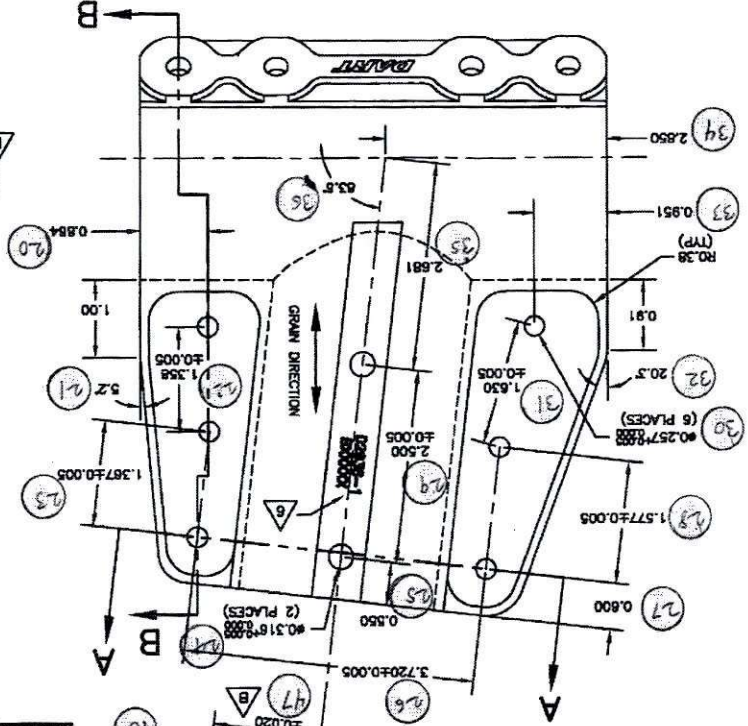
Audited by:	amc
Date:	18/08/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

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1) MATERIAL: ALUMINUM 7075-T7351 (90-A-250/12)
(WAKE FROM D6101-003 SADDLE BULLET. 7075)
2) FINISH: CHEMICAL COMPOSITION COAT PER DSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B

